

Work Order ID 79377-2
Wednesday, January 25, 2012 11:50:02 AM

79377

Page 1

Item ID: D4434-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Fwd inboard Bracket Assembly

Start Date: 1/25/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/3/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date: 12-01-25 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4434

A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut D4434-1 as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

12-1-26

2

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

12-1-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79377

Wednesday, January 25, 2012 11:50:02 AM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 1/25/2012 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 2/3/2012 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

OC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

Quality Control

130

1-Bend as per dwg

0.00

130

Brake NC

Memo

Brake NC

2. C's sink as per dwg

0.00

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

Quality Control

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 79377

Wednesday, January 25, 2012 11:50:02 AM

79377

Page 3

Item ID: D4434-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd inboard Bracket Assembly
Start Date: 1/25/2012 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 2/3/2012 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Chemical Conversion Coat per QSI005 4.1	0.00							
160									
HandFinish	Memo	0.00							
Hand Finishing									
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									
180		0.00							
180									
Small Fab	Memo	0.00							
Small Fab	Assemble as per dwg, do not install grommets and rubber seal.								

2 12-1-30

2 4 12-1-30

10 FF 12-04-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79377

79377

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Wednesday, January 25, 2012 11:50:03 AM

Item ID: D4434-043

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd inboard Bracket Assembly

Start Date: 1/25/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/3/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

185

QC5- Inspect part completeness to step on W/O

0.00

185

QC

Memo

0.00

Quality Control

190

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

190

Powdercoat

Memo

Powder Coating

0.00

200

QC3- Inspect Part Finish

0.00

200

QC

Memo

0.00

Quality Control

Start Time: 7:50
Temp: 320°F
Finish Time: 8:20

IX Ø m-l 12/04/10

1 g 11 10/04/10

M117338

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

79377

Wednesday, January 25, 2012 11:50:03 AM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

NS2

1

Cust Item ID:

1

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop *NR2*

OC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

202

0.00

202

0.00

Small Fab

Memo

Small Fab

Install rubber seals and grommets.

3M 1300 batch: 120954

205

QC5- Inspect part completeness to step on W/O

0.00

205

0.00

QC

Memo

Quality Control

210

Identify as per dwg & Stock Location: GA

0.00

210

0.00

Packaging

Memo

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID 79377***79377***

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Wednesday, January 25, 2012 11:50:03 AM

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N900040100Setup Start ***NS1***

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Item Name: Fwd inboard Bracket Assembly

Start Date: 1/25/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/3/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

12/4/12 *[Signature]*
mk
12-04-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Wednesday, January 25, 2012 11:50:07 AM

Page 1

Work Order ID: 79377

79377

Parent Item: D4434-043

D4434-043

Parent Item Name: Fwd inboard Bracket Assembly

Start Date: 1/25/2012

Required Date: 2/3/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP revA 11.10.06 new issue EC verified by:DD IPP RevB
11.12.22 per PA5 EC verified by:JLM IPP RevC 12.01.24
per REV.A DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.040

Purchased

No

100

sf

330.9100

2.5

2.631579

M6061T6S 040

6061-T6 .040 Sheet

**

B12-1-X

Location

Loc Qty

Loc Code

MAT021

330.91

113004

2.5

117653

40.91

120154

95.5

120218

192

D0218

(2)

D4434-9

Manufactured

No

180

Each

0.0000

1

1

D4434-9

Bracket

**

① FF 12-04-04

D4435-041

Manufactured

No

180

Each

0.0000

1

1

D4435-041

Bracket Assembly

**

① FF 12-04-04

D4441-1

Manufactured

No

202

f

35.4840

0.142

0.142

D4441-1

Rubber Seal

**

① FF 12-04-10

Location

Loc Qty

Loc Code

prelim

35.484

74760

35.484

79385

0.142

Cut qty 1 to 1.7"

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 2

Wednesday, January 25, 2012 11:50:07 AM

Work Order ID: 79377

79377

Parent Item: D4434-043

D4434-043

Parent Item Name: Fwd inboard Bracket Assembly

Start Date: 1/25/2012

Required Date: 2/3/2012

Start Qty: 1.00

Required Qty: 1.00

D4441-1 Manufactured No

f 35.4840 0.208

D4441-1

Rubber Seal

**

① FF 12/04/10

Location	Loc Qty	Loc Code
prelim	35.484	
74760	35.484	

Cut qty 1 to 2.5"

D4441-1 Manufactured No

f 35.4840 1.875

D4441-1

Rubber Seal

**

① FF 12/04/10

Location	Loc Qty	Loc Code
prelim	35.484	
74760	35.484	

Cut qty 1 to 22.5"

D4440-1 Manufactured No

202 Each 2.0000 1 1

D4440-1

Grommet

**

① FF 12/04/10

Location	Loc Qty	Loc Code
prelim	2	
74759	2	

AN525-832R6

Purchased No

180 Each 44.0000 3 3

AN525-832R6

Screw

**

① FF 12/04/10

Location	Loc Qty	Loc Code
ST345	20	
120308	20	

ST346	24	
118612	24	

120560

3

Wednesday, January 25, 2012 11:50:07 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Wednesday, January 25, 2012 11:50:07 AM

Work Order ID: 79377

79377

Parent Item: D4434-043

D4434-043

Parent Item Name: Fwd inboard Bracket Assembly

Start Date: 1/25/2012

Required Date: 2/3/2012

Start Qty: 1.00

Required Qty: 1.00

MS20426AD3-2 ³ Purchased

No

180

Each

18,319.00

12

12

MS20426AD3-2

Rivet

**

① FF 12-04-04

Location

Loc Qty

Loc Code

Mezz 121011
1173
13276

18319
8919
9400

12

MS20426AD3-3 ⁴ Purchased

No

180

Each

3,315.000

2

2

MS20426AD3-3

Rivet

**

① FF 12-04-04

Location

Loc Qty

Loc Code

ST316 104374
119109
19099

3315
2812
503

2

MS20470AD4-3 Purchased

No

180

Each

5,950.000

5

5

MS20470AD4-3

Rivet - Universal Head

**

① FF 12-04-04

Location

Loc Qty

Loc Code

Mezz
1642
2193

5950
1316
4634

MS21075L08 Purchased

No

180

Each

78.0000

7

7

MS21075L 08

ANCHOR NUT

**

① FF 12-04-04

Location

Loc Qty

Loc Code

ST303 120560
111578
ST304
120121

3
3
75
75

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order: 74377

Part Number: D4434-043

Page 1 of 1

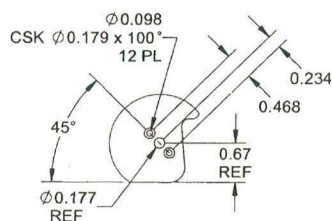
X	First Article	X	Prototype
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Measured by: B	Audited by: S	Prototype Approval:
Date: 12-1-26	Date: 12/1/26	Date:

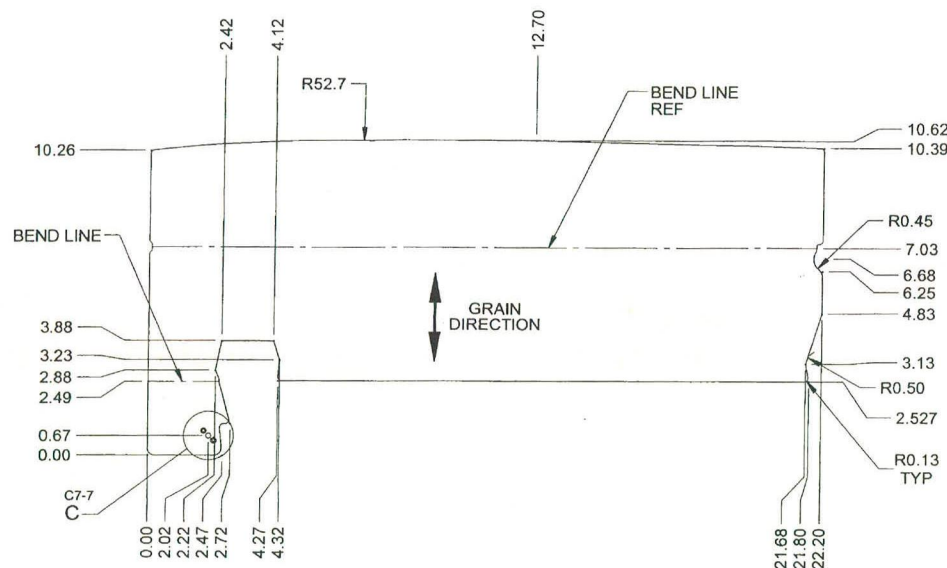
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 79377

pl 12-01-29



DETAIL C B6-7
SCALE 2X



D4434-1F FLAT PATTERN

NOTES:

1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 0.70 lbs

DESIGN	RF	DART AEROSPACE LTD HAMMERSBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D4434	REV. A
MFG. APPR.			SHEET 7 OF 15
APPROVED		TITLE COVER ASSEMBLY	SCALE NTS
DE APPR.		COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	12.01.17		

RELEASED
2012-01-23
MP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

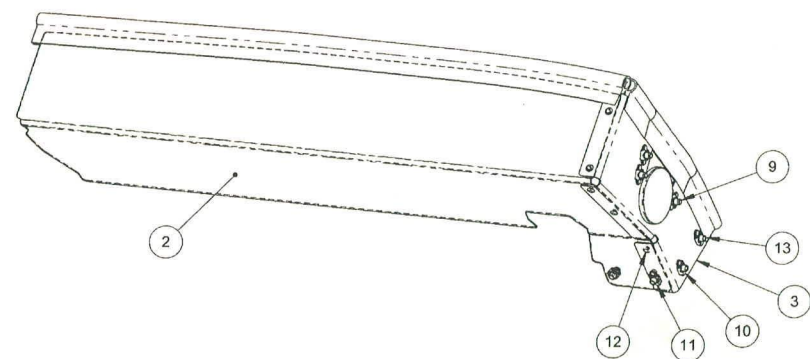
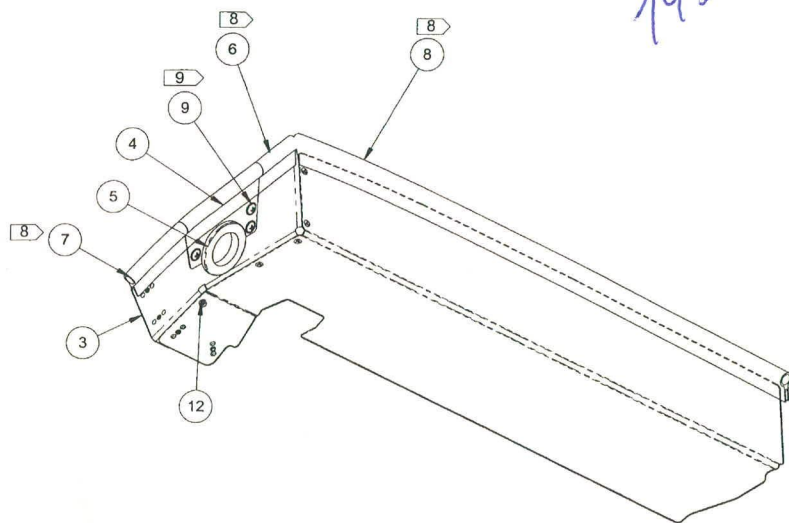
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

19377



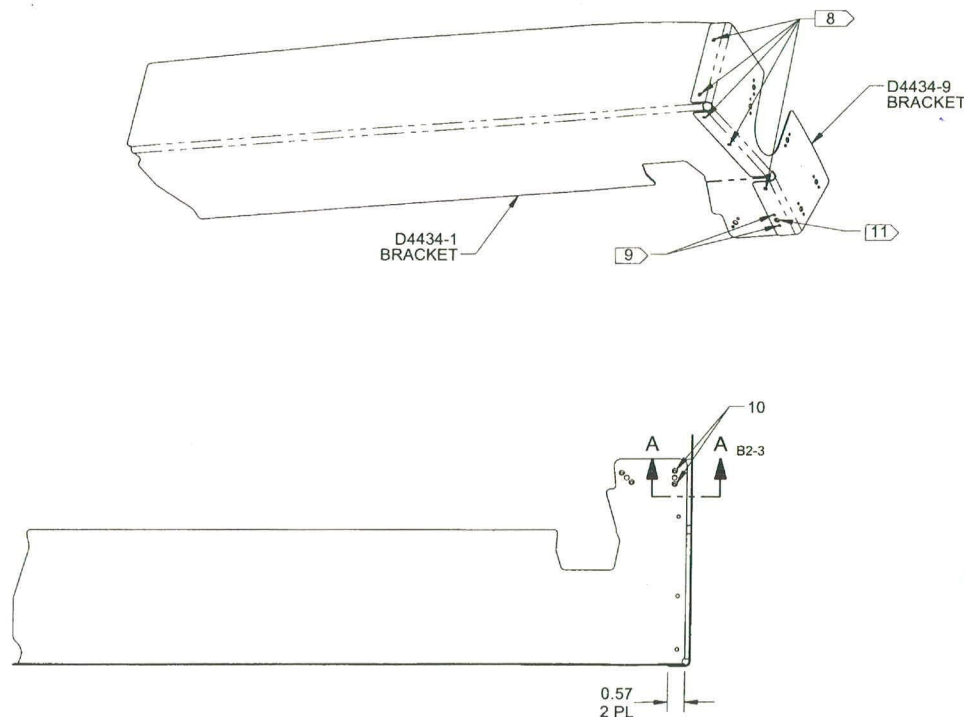
ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D4434-043	FWD INBOARD BRACKET ASSEMBLY
2	1	D4434-1	BRACKET
3	1	D4434-9	BRACKET
4	1	D4435-041	BRACKET ASSEMBLY
5	1	D4440-1	GROMMET
6	1	D4441-1-017	RUBBER SEAL
7	1	D4441-1-025	RUBBER SEAL
8	1	D4441-1-225	RUBBER SEAL
9	3	AN525-832R6	SCREW
10	12	MS20426AD3-2	RIVET
11	2	MS20426AD3-3	RIVET
12	5	MS20470AD4-3	RIVET
13	7	MS21075L08	NUT PLATE
14	A/R	3M 1300/1300L	ADHESIVE

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
 - 3) MASK NUT PLATE HOLES
 - 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 7) IDENTIFICATION: N/A
 - 8) WEIGHT: 1.04 lbs
 - 9) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE
 - 10) ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL
 - 11) IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING
 - 12) TORQUE SCREW TO 12-15 (in-lb)

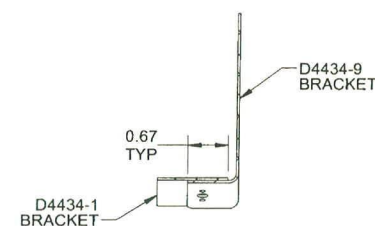
D4434-043 FWD INBOARD BRACKET ASSEMBLY

RELEASED
2012-01-23

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4434	SHEET 2 OF 15
APPROVED		TITLE	SCALE
DE APPR.		COVER ASSEMBLY	NTS
DATE	12.01.17	COPYRIGHT © 2012 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



19377



SECTION A-A C4-3

D4434-043 FWD INBOARD BRACKET ASSEMBLY
AUXILIARY VIEW

NOTES:

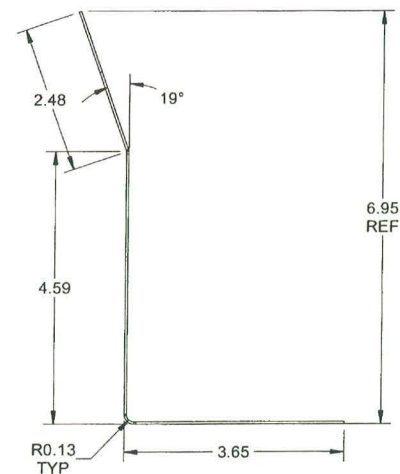
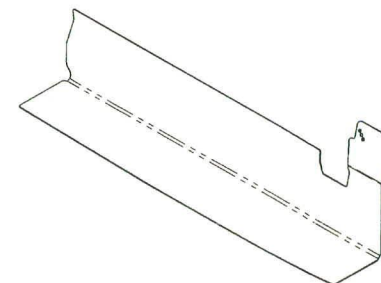
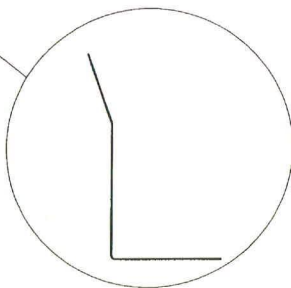
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.04 lbs
- 8) TRANSFER $\varnothing 0.129$ HOLES THRU 5 PLACES FROM D4434-9 TO D4434-1
- 9) TRANSFER $\varnothing 0.098$ HOLES THRU 2 PLACES FROM D4434-9 TO D4434-1
- 10) CSK $\varnothing 0.179 \times 100^\circ$ ON THIS SIDE 2 PLACES
- 11) TRANSFER $\varnothing 0.177$ HOLE THRU FROM D4434-9 TO D4434-1

RELEASED
2012-01-23

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4434	SHEET 3 OF 15
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	COVER ASSEMBLY	NTS
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19377

B
B2-6



D4434-1 BRACKET

DETAIL B C8-6
SCALE 2X

RELEASED
2012-01-23
JW

NOTES:

- 1) MATERIAL: MAKE FROM D4434-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4434	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 6 OF 15	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	COVER ASSEMBLY	
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